

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001855**Date Inspected:** 18-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

PQR - HP2008021

Quality Assurance Inspector Brannon periodically observed ZPMC welder's Mr. Rhu Hai Ping and Zhang Xin Jin, welding root and fill passes for Procedure Qualification Record Test (PQR) #HP-20080211. Base metal was designated as A-709 Grade HPS-485W/Z25 and back bar metal A-709 Grade HPS-. Mr. Rhu and Zhang was observed welding in the 1G (flat), position utilizing a flux cored arc welding (FCAW) process using a 1.4mm diameter electrode, classification E71T-12J H4, Brand: KISWEL K-71TSR, on a motorized track. QA Inspector observed preheat and welding parameters measured by the QC Inspector Mr. Huang Wei. Mr. Wei was assisted by Mrs. Mung. Also, observing was American Bridge/Fluor Quality Control Inspector (QC) Mr. Craig Knops. Welders Mr. Rhu Hai Ping and Zhang Xin Jin deposited fourteen weld passes on this date. Note: See ABF-RFI-001215R00. Mr. Knops stated that ZPMC has not produced a mill certificate that states that this consumable meets AWS A4.2 H4 and that the PQR tests will not be acceptable until all parties involved has received a copy.

The following digital photograph below illustrates observation of the activities being performed.

WELDING INSPECTION REPORT

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Summary of Conversations:

As stated within the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer